

Work Order ID 65549

January 19, 2011 1:38:47 PM



Page 1

Item ID:	D3065-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Step Spacer					
Start Date:	1/20/11	Start Qty:	40.00		Cust Item ID:	
Required Date:	1/28/11	Req'd Qty:	40.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>mr</u>	Date:	<u>1/20/11</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3065	Rev B								

100
 FLOW WATER JET 0.00
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3065 ☒ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
 2024 .040 Debur as required

1B1-1-25

(50)

110
 QC2- Inspect parts off machine FAI/FAIB 0.00
 QC Memo 0.00
 Quality Control

1B1-1-25

120
 QC8- Inspect parts - second check 0.00
 QC Memo 0.00
 Quality Control

8/10/126

counts
 (XSD)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3065-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Spacer

Start Date: 1/20/11

Start Qty: 40.00



Cust Item ID:

Required Date: 1/28/11

Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

Deburr if necessary.

0.00

0.00

WLAS

140



Brake NC

Brake NC

NC BRAKE

Memo

Bend as per Dwg D3065

0.00

0.00

SP 11/02/01



150



QC

Quality Control

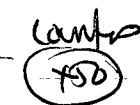
QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Subtotal



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Item ID: D3065-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Spacer

Start Date: 1/20/11 Start Qty: 40.00



Cust Item ID:

Required Date: 1/28/11 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

11

11/02/04

50

9

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

50 BR 11-02-4

180

Identify as per dwg & Stock Location Small Job

0.00



Packaging

Memo

0.00

Packaging

11/2/04 - sf (500)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Setup Start



Revision ID:

Stop



Item Name: Step Spacer

Start Date: 1/20/11 Start Qty: 40.00



Cust Item ID:

Required Date: 1/28/11 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CZ11/02/09

11/02/09 [Signature]

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 65549



Parent Item: D3065-1



Parent Item Name: Step Spacer

Start Date: 1/20/11

Required Date: 1/28/11

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: ☐ C ☐ 02.11.01 ☐ Incorporated D3066-1 IPP ☐ KJ/RF ☐
IPP: ☐ D ☐ 06.04.25 ☐ Water jet EC ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.040

Purchased

No

100

sf

216.4595

0.1238

5.212632

6.4



181-1-25

2024-T3 .040 sheet

Location

Loc Qty

Loc Code

MAT

28.2

114415

28.2

MAT22

188.2595

110305

21.93

111786

9.66

112291

28.25

112331

52

113162

76.4195

112291

(51)

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DART AEROSPACE LTD		Work Order: 65649
Description: Step Spacer		Part Number: D3065-1
Inspection Dwg: D3065	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+/-0.010	.249	✓		V 1B02	
2.093	+/-0.010	2.090	✓		V	
3.936	+/-0.010	3.936	✓		V	
4.186	+/-0.010	4.190	✓		V	
0.587	+/-0.010	.585	✓		V	
Ø0.128	+0.005/-0.001	.133	✓		V	
R0.125	+/-0.010	.125	✓		R.G.	
3.465	+/-0.010	3.464	✓		V	
Ø1.250	+0.012/-0.001	1.253	✓		V	
0.368	+/-0.010	.366	✓		V	
0.871 (Pitch)	+/-0.005	.871	✓		V	
0.040	+/-0.010	.042	✓		V	

Measured by: IB	Audited by: S	Prototype Approval:
Date: 11-1-25	Date: 11/01/26	Date:

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	KJ/RF	
B	06.06.23	Dwg Rev. changed	KJ/JLM	
C	07.02.07	Dimension 0.040 added	KJ/JLM	

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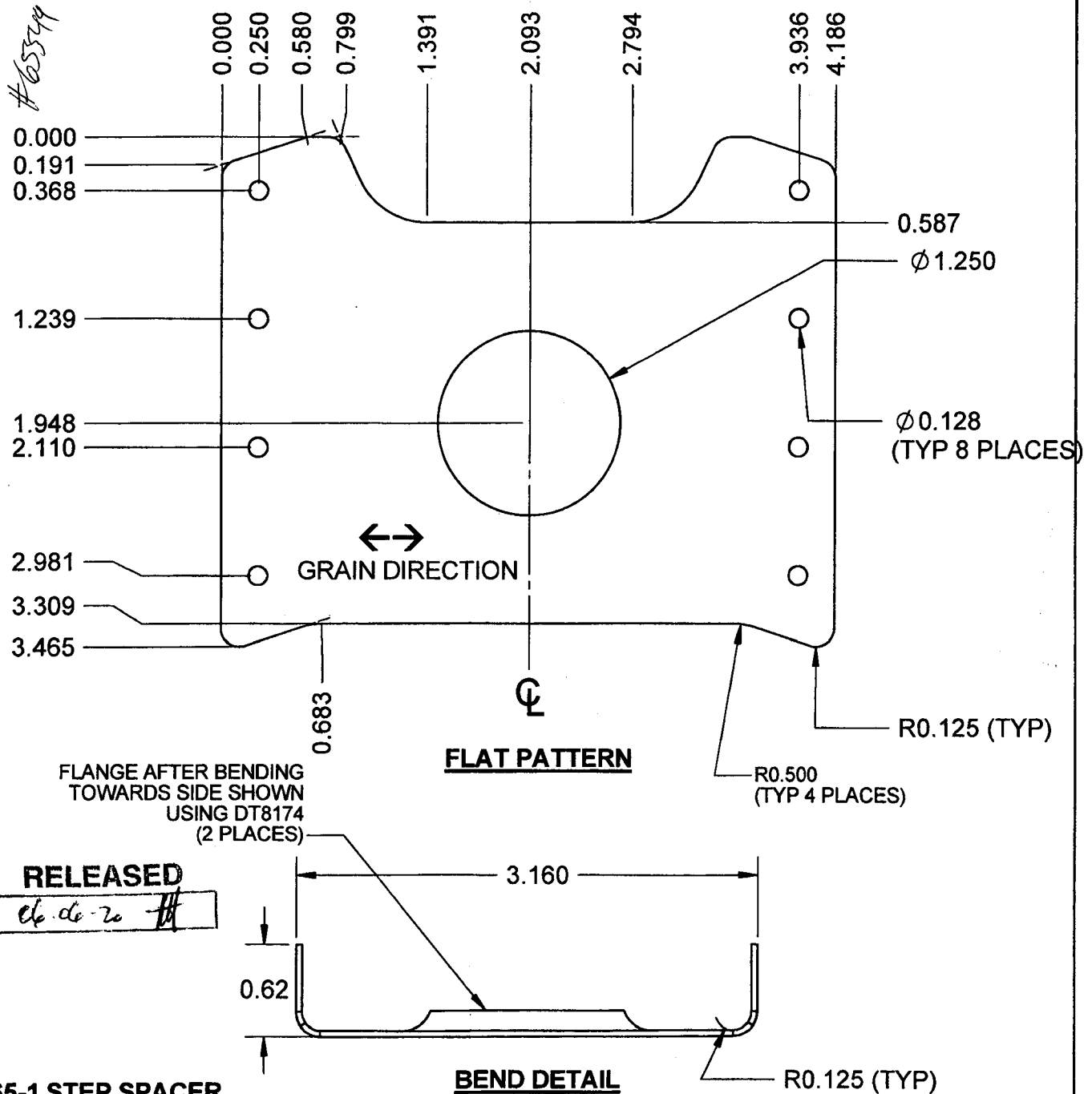
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DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:1

**D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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